

Date: Thursday, 12/15/2005 4:05:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PATIENT STOP
Job Number	: 25271		
Estimate Number	: 11490		
P.O. Number	: N/A	Part Number	: D2492
This Issue	: 12/15/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2492 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: D
Written By	: SEE COMMENT BELOW	Material	: MAKE in multiple of 10
Checked & Approved By	: SEE COMMENT BELOW	Due Date	: 12/23/2005
Comment	: Est. E 00.06.26 Removed P/O for powder coat EC	Qty:	16 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 1.9140 sf(s)/Unit Total: 30.6247 sf(s)
 5052-H32 .080 Sheet
 Material: 5052-H32 (QQ-A-250/8) 0.080" thick
 (M5052H32S.080)
 Batch M19052

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks: 8.000" x 25.942"

J.L 06.02.01 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per Folio FA041

J.L 06.02.01 19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.01 19

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr
 Form using Jig DT2492B

DL 06/02/06 19
 SAD 06/02/08 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/02/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-01	3	- 1 part in stack of 10 was cut to short dimension is $8.000^{+0.030}$ and part is 7.938 didn't machine edges.		Scrap and destroy	SL 06-02-01	2 06-02-01		2 06-02-01

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PATIENT STOP

Job Number: 25271

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



200209

Comment: INSPECT WORK TO CURRENT STEP

910

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-02-12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 02 10

19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 180*

0206102115

(19)

10.0

DC

DOCUMENT CONTROL



(19)

Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/16 (19)

06102116

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-02-09	6-1	Add. Baseline as per QS1 005. 4.1 (check for approval) Add to S.P.D. (permanent change)	E	06-02-16			 06-02-09

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:
 QA: N/C Closed: _____ Date: _____

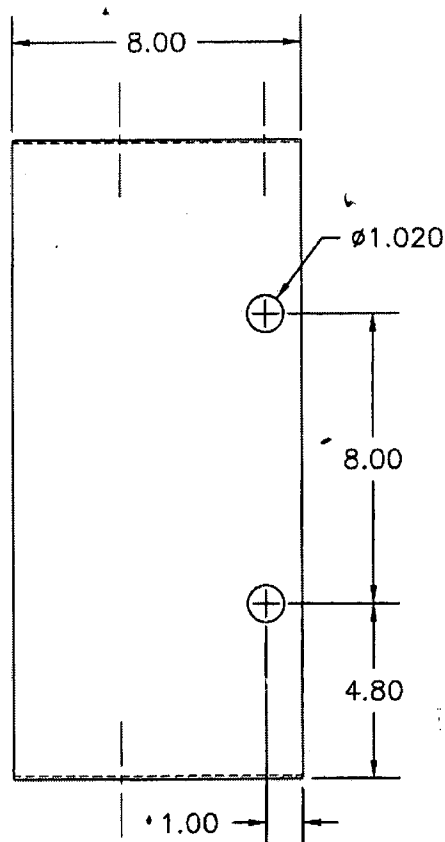
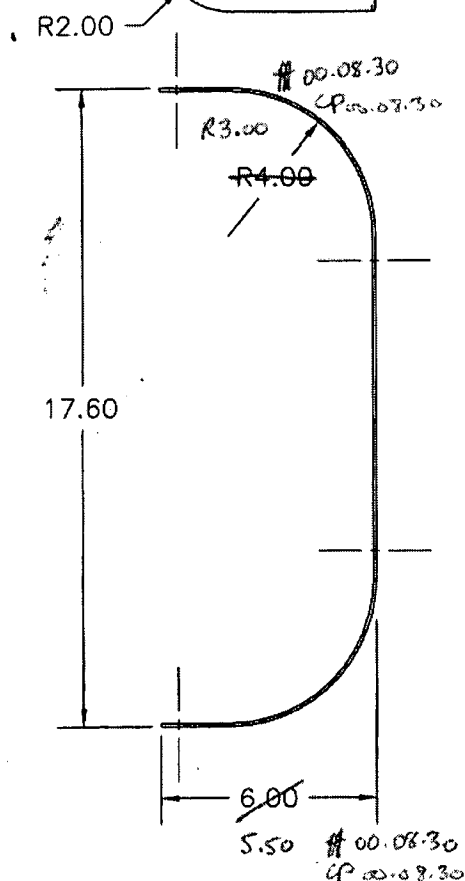
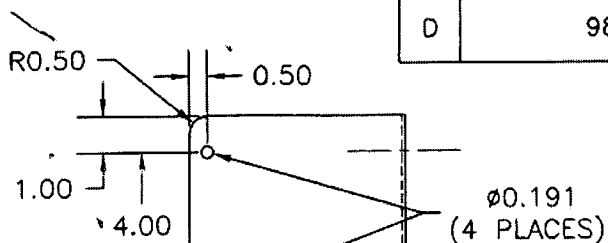
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED KE	DRAWING NO. D2492	REV. 0 SHEET 1 OF 1
DATE 98.05.11		TITLE PATIENT STOP	SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	

RELEASED
98/06/15 KE



CHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
NOT TO
BE USED

25271

MATERIAL: 5052-H32 QQ-A-250/8 0.080 THICK
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

DART AEROSPACE LTD		Work Order:	25271
Description: patient stop		Part Number:	D2492
Inspection Dwg: A2492 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by: J.L.	Audited by: gml	Prototype Approval:
Date: 06-02-01	Date: 06/02/01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	